

Date: Wednesday, 09/07/2008 1:32:14 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40406
Estimate Number : 13458
P.O. Number :
This Issue : 09/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run :
Written By :
Checked & Approved By :
Comment : Est Rev: A New issue 08-07-09 JLM Verified By: EC

Drawing Name : WASHER
Part Number : D34175
Drawing Number : D3417 PREL
Project Number : N/A
Drawing Revision : PREL
Material :
Due Date : 16/07/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELRLNR12500 DELRLIN ROUND BAR 1.25"



Comment: Qty.: 0.0311 f(s)/Unit Total : 1.2432 f(s)
Material: Delrin Round Bar Ø1.250
(M-DELRLIN-R1.250)
Batch: 107961
Identify for D3417-3

20 08/07/28

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA761 Rev: per & Dwg D3417 Rev: per
2-Deburr

20 08/07/28

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/07/28 (81)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/07/31 P10 →

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Scrap per ECN 08-507

POSITIVE RECALL
EFFECTIVE 08-07-09 AUTH u
RELEASED _____ DATE _____

08/08/12
(87) Hm

RE PARTS WITH 0.200 dim are scrap b/c it will not be
01-06-01 compatible with D3407-045 Tow rings

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 40406

Part Number: D34175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 8/08/15

Job Completion



MF 08-08-14

DART AEROSPACE LTD		Work Order:
Description: Crosstube Assembly		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	1.125	+ .030	1.145				
	.641	+ .008 - .001	.641				
	.331	+/- .010	.374				
	.810	+ .010	.811				
	.200	+ .020	.213				
	R 2.00	+/- .030	R 2.0				
SIDE B							

Measured by: <i>PC</i>	Audited by: <i>J.L</i>	Prototype Approval:	N/A
Date: 08/07/08	Date: 08/07/31	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue	KJ/JLM
			Approved

ENGINEERING CHANGE NOTICE DART AEROSPACE LTD

Date: 08.07.29	Job No.:	ADR Yes/No: Y	ADR Date: 08.07.29	ECN #: 08- 507
Product No.: D205-634 / D204-635		Created By: [Signature]	Approved By: [Signature]	
Product Name: SKIDTUBES		Checked By: [Signature]	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	JLM	
Production Document Control	Y	JLD	
Customer Technical Support	Y	DS/MB	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	Y	JM	
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change:

PRODUCTION - NEW METHOD TO MANUFACTURE TOW RINGS

Documents Affected:

Release: DSI 9417 Rev. A, DSI 9418 Rev. A, D3407 Rev. E, D3417 Rev. D, D3812 Rev. A

PARTS MUST COMPLY

PREVIOUS PARTS SATISFACTORY

X

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatibility Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ	See below	08.08.01 [Signature]
10	Update Controlled PDF Files	Y	KJ		08.08.01 [Signature]
11	Update Master Document List (MDL) <i>Rev. D</i>	Y	PH		08.08.01 [Signature]
12	Update Document Record (DR) <i>Rev. K</i>	Y	KJ		08.08.01 [Signature]
13	Update Product Development Summary	N			08.08.01 [Signature]
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	Y	KJ	See below	08.08.01 [Signature]
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	See below	08.08.01 [Signature]
18	Create / Update PPP's	Y	KJ	See 17)	08.08.01 [Signature]
19	Update Document Control Database / Laminated Dwgs	N			08.08.01 [Signature]
20	Update Grey Project Binder	Y	KJ	ADR	08.08.01 [Signature]
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		08.08.01 [Signature]
22					08.08.01 [Signature]
23					

Description / Action:

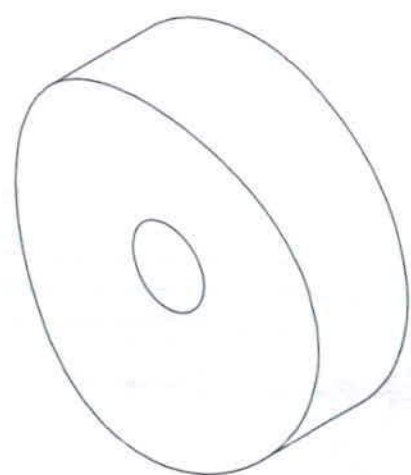
- 9) DSI 9417 is for D205-634 kits. Include DSI 9417 for D205-634-011 @ CHG 006 and D205-634-015 @ CHG 005
- 9) DSI 9418 is for D204-635 kits. Include DSI 9418 for D204-635-011 @ CHG 006
- 15) New parts see DSI 9417 and DSI 9418
- 17) Installations that have been modified with DSI 9417: D205-634-011 @ CHG 006 and D205-634-015 @ CHG 005
- 17) Installations that have been modified with DSI 9418: D204-635-011 @ CHG 006

DO NOT SEND DIFFERENT CHANGE NUMBERS TOGETHER

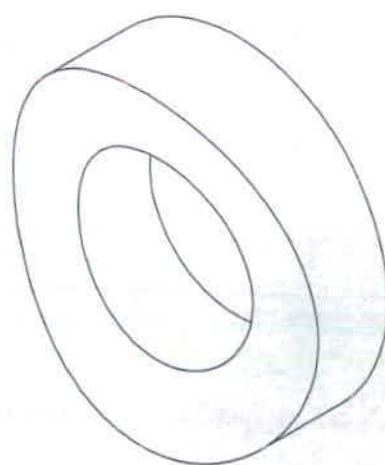
- ** D3407-045 WAS INITIALLY MADE ON PRELIMINARY DRAWING D3803-041**
- ** D3407-7 WAS INITIALLY MADE ON PRELIMINARY DRAWING D3803-1**
- ** D3417-5 MADE BEFORE 08.08.01 ARE OBSOLETE AND ARE SCRAP**
- ** D205-634-011/015 AND D204-635-011 PICK KIT HAS BEEN UPDATED, SEE DSI's**

ECN Verified & Complete:

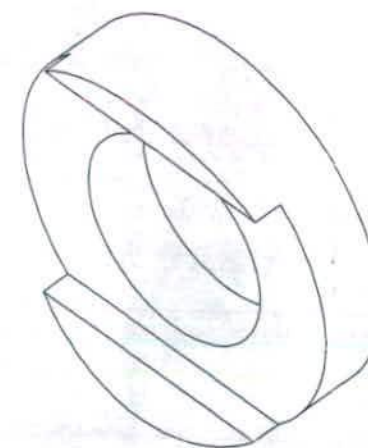
Date:



D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER \triangle

PRELIMINARY ISSUE
FOR D3417-5
REV 03.07.24

NOTES:

1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

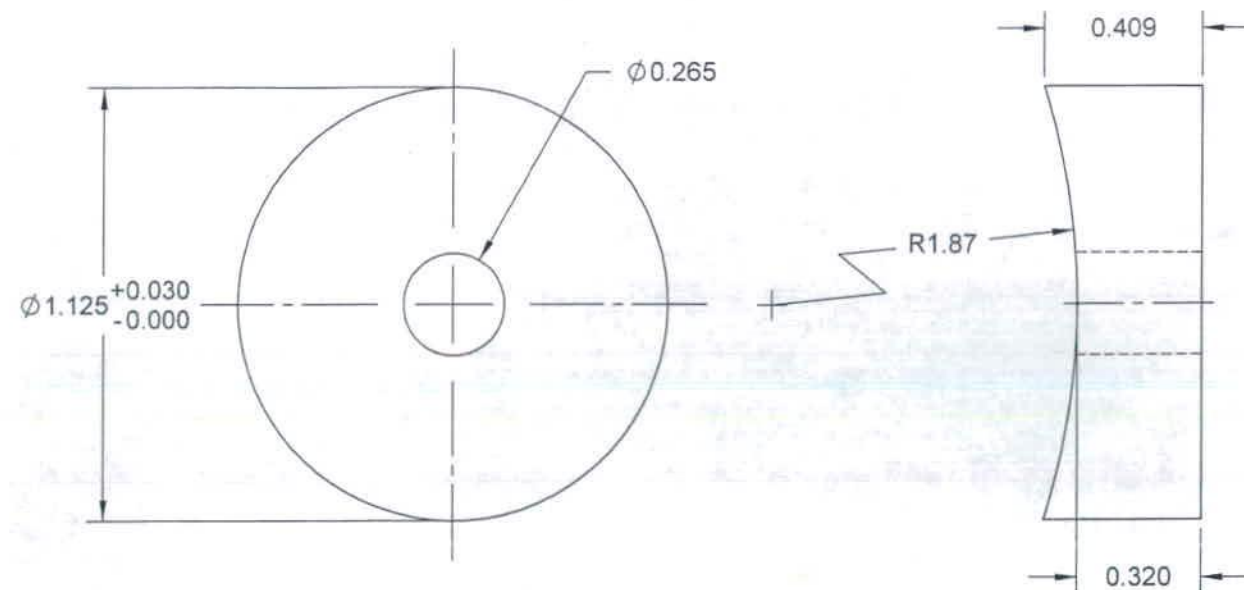
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

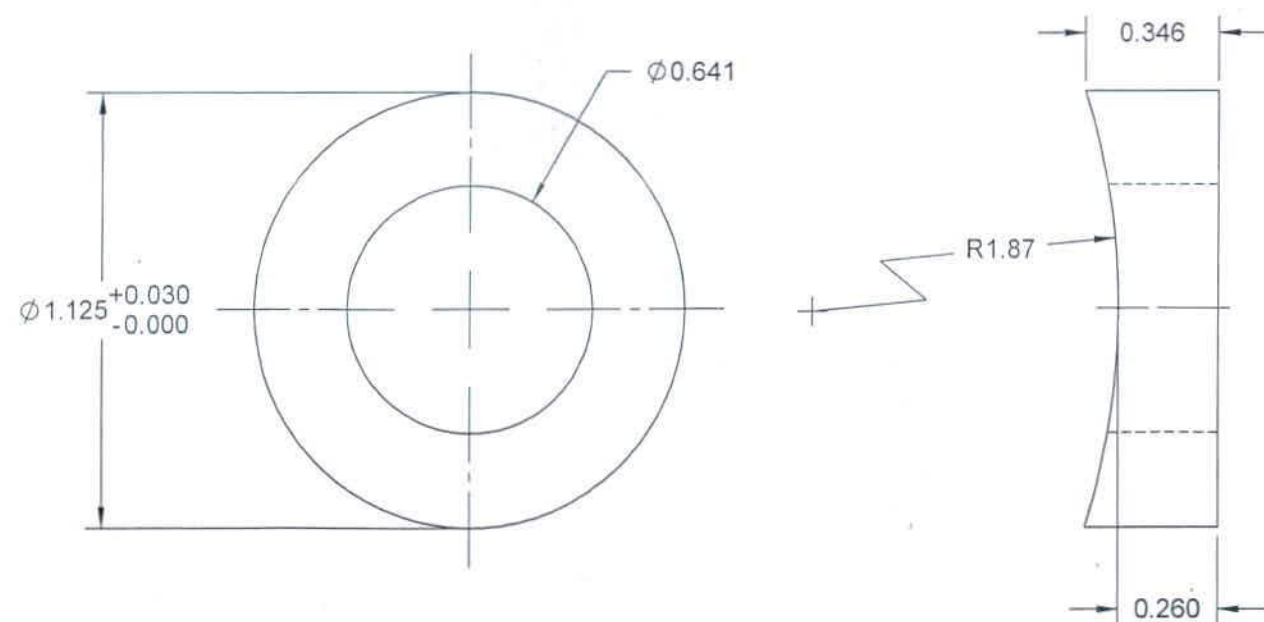
7) WEIGHT: D3417-1, 0.02 lbs
D3417-3, 0.01 lbs
D3417-5, 0.01 lbs

D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3417	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	08.07.08	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

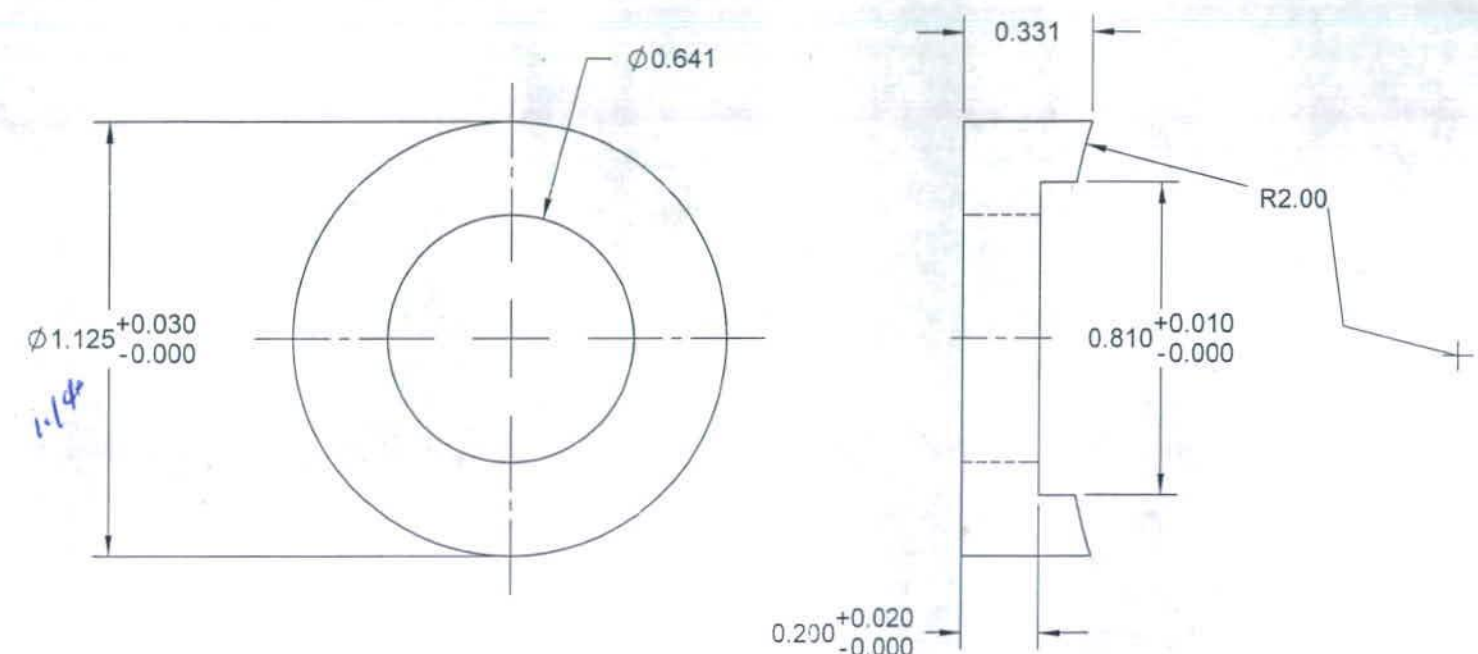
REF ID: A12215



D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER D

PRELIMINARY ISSUE
FOR D3417-5
REV 03.07.24

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3417	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	08.07.08	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

